

Amendments to the Claims

This listing of the Claims will replace all prior versions and listings of the claims in this patent application.

Listing of the Claims

1. (currently amended) A method of fabricating a composite tubular door frame comprising the steps of:
 - (a) laying-up a plurality of layers of ~~prepreg~~ composite fabric on a mould having an upper mould component and a lower mould component, and each layer of ~~the~~said composite fabric being compacted;
 - (b) placing a plurality of nylon tubes over ~~the~~said composite fabric at ~~the~~said upper mould component with ~~the~~ ends of ~~the~~said nylon tubes being extended out at each of the corners of ~~the~~said mould and ~~to be sealed with~~ placing a main bag ~~placed~~ over the top and envelopeing ~~the~~said upper mould component and sealing said nylon tubes;
 - (c) proceeding the mould to a curing step wherein ~~with a curing pressure is applied of~~ ~~4 to 7 bars with 0.3 to 0.7 bar vacuum, the mould being heated in an autoclave to 80 degree C and hold for 30 min to 1.5 hour with 0.3 to 0.7 bar of vacuum in the enclosure enveloped by the~~ said main bag and sealeding with the said nylon tubes;
and

- (d) thereafter removing the said main bag from the said mould and the pulling out said nylon tubes being pulled out of from the said mould and removing the said mould to obtain a tubular door frame.
2. (currently amended) The method of claim 1, wherein the said composite fabric is selected from the group consisting of glass, or carbon, boron, and aramid and wherein said composite fabric is pre-impregnated with epoxy resin.
3. (currently amended) The method of claim 1 ~~or 2~~, wherein said the curing pressure is 4 to 7 bars with a 0.3 to 0.7 bar vacuum. temperature is 120 degree C.
4. (currently amended) The method of claim ~~3~~ ~~or 2~~, wherein said mould is heated in an autoclave to 80 degrees C and held for 30 to 90 minutes. the curing temperature is 180 degree C.
5. (currently amended) The method of ~~any one of claims 1 to 4~~, wherein the said curing pressure applied to the said autoclave during the said 80 degrees C is 4 bars.
6. (currently amended) The method of ~~any one of claims 1 to 5~~, wherein after said holding for 30 to 90 minutes, the temperature of the said autoclave is gradually increased to 120 or 180 degrees C.

7. (currently amended) The method of ~~any one of claims 1 to 6~~, wherein ~~the~~said temperature of 120 or 180 degrees C is ~~held~~ for 2 hours before cooling to room temperature.
8. (currently amended) A method of fabricating a composite tubular frame comprising the steps of
- (a) laying-up a plurality of layers of ~~prepreg~~ composite fabric on a mould having an upper mould component and a lower mould component, and each layer of the said composite fabric being compacted;
 - (b) placing a plurality of nylon tubes over the said composite fabric at the said upper mould component with ~~the~~ ends of the said nylon tubes being extended out at each of the corners of the said mould ~~to be sealed with~~ and placing a main bag placed over the top and envelopeing the said upper mould component and sealing said nylon tubes;
 - (c) proceeding the said mould to a curing step with a wherein curing pressure of ~~4 to 7 bars with 0.3 to 0.7 bar vacuum, the mould being heated in an autoclave to 80 degree C and hold for 30 min to 1.5 hour with 0.3 to 0.7 bar of vacuum is applied~~ in the enclosure enveloped the by said main bag and sealeding with the said nylon tubes;
 - (d) thereafter removing the said main bag from the said mould and the pulling said nylon tubes ~~being pulled out of~~ from the said mould and removing the said mould to obtain a tubular door frame; and
 - (e) trimming off of excessive said composite fabrics from the said tubular door frame obtained in step (d).

9. (currently amended) The method of claim ~~1-or~~ 8, wherein the said curing pressure applied to the autoclave is preferably is 4 to 7 bars with a 0.3 to 0.7 bar vacuum.

10. (currently amended) The method of claim ~~1-or~~ 8, wherein the vacuum applied in the said curing step is 0.5 bar.

11. (currently amended) The method of claim ~~1-or~~ 8, wherein the said nylon tubes pressurize the inner wall of the said composite fabric during curing.

12. (currently amended) The method of claim ~~1-or~~ 8, wherein the said composite fabric is selected from the group consisting of carbon, glass, boron, and aramid and wherein said composite fabric is pre-impregnated with epoxy resin.

13. (new) The method of claim 8, wherein said mould is heated in an autoclave to 80 degrees C and held for 30 to 90 minutes.

14. (new) The method of claim 9, wherein said curing pressure applied to said autoclave during said 80 degrees C is 4 bars.

15. (new) The method of claim 10, wherein after said holding for 30 to 90 minutes, the temperature of said autoclave is gradually increased to 120 or 180 degrees C.

16. (new) The method of claim 11, wherein said temperature of 120 or 180 degrees C is held for 2 hours before cooling to room temperature.

17. (new) The method of claim 4, wherein the pressure applied to said autoclave is preferably 4 bars.

18. (new) The method of claim 1, wherein the vacuum applied in said curing step is 0.5 bar.

19. (new) The method of claim 1, wherein said nylon tubes pressurize the inner wall of said composite fabric during curing.